

Work Order ID 58480

May 7, 2010 10:18:09 AM



Page 1

Item ID: D2600-3-120

Accept



Setup Start



Revision ID:

Stop



Item Name: Extrusion Round 3" 350

Start Date: 5/07/10 Start Qty: 80.00



Cust Item ID:

Required Date: 5/21/10 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2600

Rev D1

100

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 11854 a) Extrude as per Dwg D2600 b) Material:
6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d)
Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f)
Order at 120" long g) Bon L Canada Inc. tool #

CD 10/5/17 (80)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

Copy 26 (27)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Check Pull test per Dwg D2600 for compliance page attached Check hardness
with Webster tester

Schultz

Combs
(77)
QSPU 7

Work Order ID 58480

May 7, 2010 10:18:10 AM



Page 2

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *46*

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/31
77

10/05/31
CL1015/31

Picklist Print

May 7, 2010 10:18:08 AM

Page 1

Work Order ID: 58480

Parent Item: D2600-3-120

Parent Item Name: Extrusion Round 3" 350


Comments: IPP D: 02.09.10: Added DSK 066 KJ/RF

Start Date: 5/07/10

Required Date: 5/21/10

Start Qty: 80.00

Required Qty: 80.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2600-3-120P		Purchased	No			100	Each	0.0000	1			
												
Extrusion Round 3" 350												



6/14/10/28 (22)



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS + DIE NUMBERS <i>4 GP</i>	

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *58-180*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

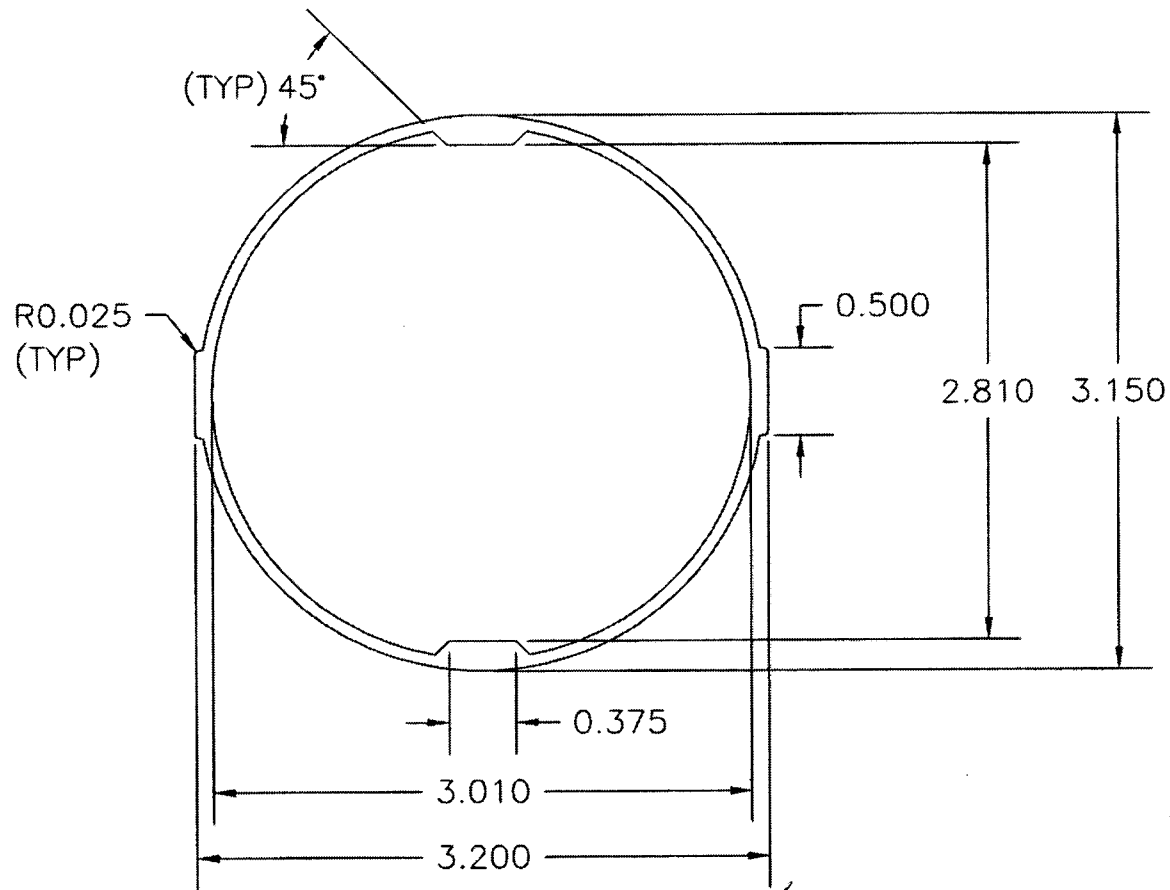
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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u1058480

D2600-1



MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

RELEASED
98825 DS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

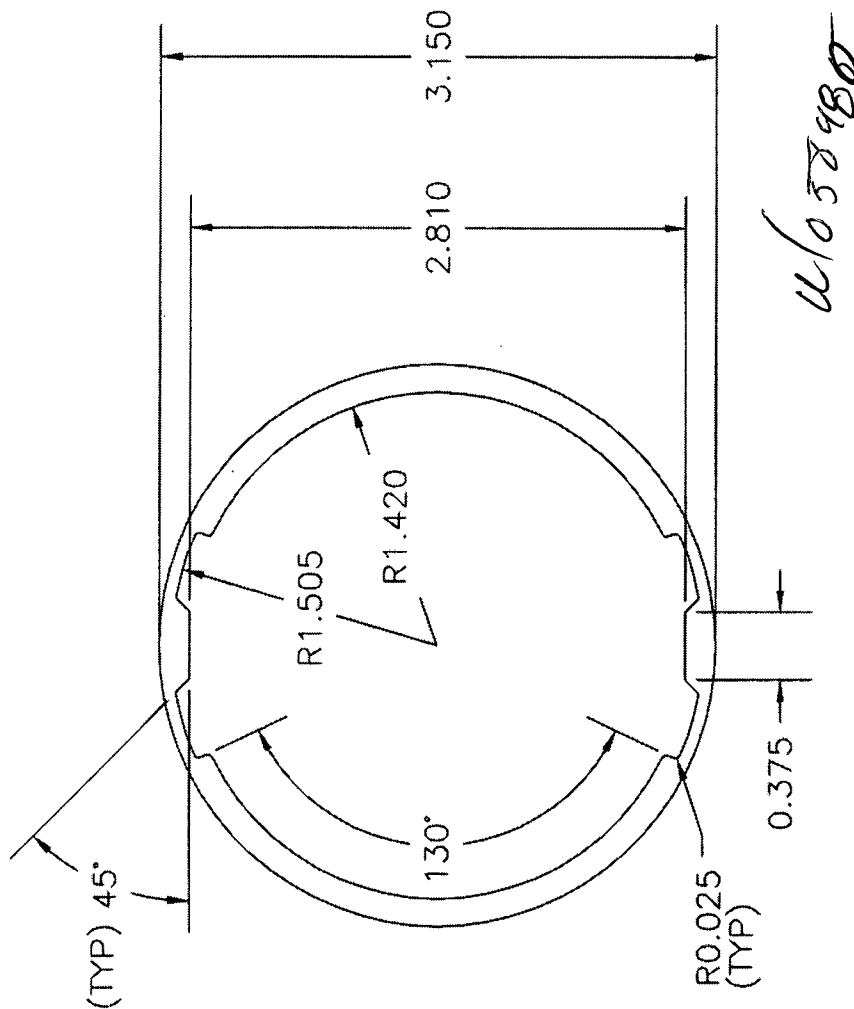
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DIA</i>	DRAWN BY <i>DIA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SA</i>	DRAWING NO. D2600	REV. 0 SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

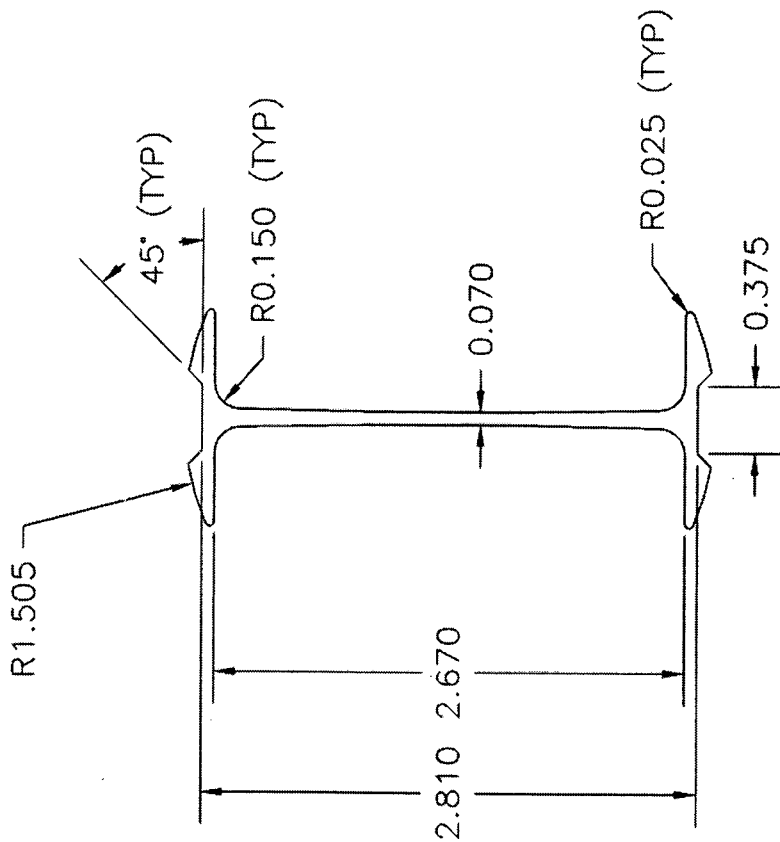
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>ME</i>	DRAWN BY <i>ME</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED
98.8.25 DS



w/0 584188

D2600-5

MANUFACTURED WITH CARADON INDALOX DIE # MS-18871

PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

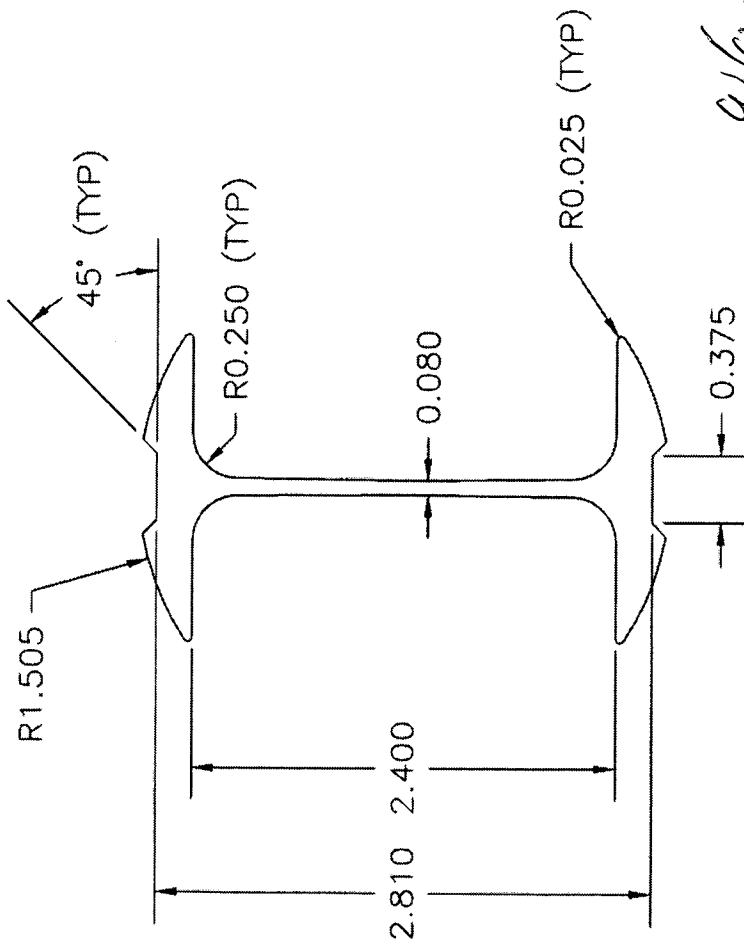
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



w/c 58480

D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11854

Purchase Order Date 5/07/10

PO Print Date 5/07/10

Page Number 1 of 2

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name

Vendor Phone

800 563 1079

Vendor Fax

800 565 8339

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
5/10/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2500-1-190P	Ext'n -I' Beam Tube 4"	5/24/10 Yes	80.00 Each	Yours ppd	\$74.3030	\$5,944.24
Special Inst: AS PER DWG D2500 REV. H B58427 MATERIAL: 6061-T6 AS PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221 MINIMUM YIELD TENSILE STRENGTH = 35 KSI MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI MINIMUM ELONGATION = 8% LENGTH: 190" BON L CANADA TOOL: 897105 TO BE PACKED PER DSK 066 PULL TEST TO ASTM STANDARD B221 REQUIRED							
2	D2600-3-120P	Extrusion Round 3" 350	5/24/10 Yes	80.00 Each	Yours ppd	\$44.3380	\$3,547.04

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 5/07/10



INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

ACCT# 00046024

MANIFEST DATE	05-25-10
MANIFEST NUMBER	680001
SALES ORDER NUMBER	63179

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

CREDIT REP
HAMBROOK, PAU
905-508-3250

SALES REP

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN
PHONE 613-632-5200	PHONE 613-632-5200

TERMS / FREIGHT
O / P

LOCATION PIC	TRAILER NUMBER JODEE	SALESMAN 59358	FIELD SALES REP Kulter A 450-435-6551	CUST SERVICE REP Burton D 905-427-2227
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CUSTOMER ID 46024	ORDER DATE 05/07/10	CUSTOMER PO NUMBER 11854
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JOB	BILL OF LADING NUMBER 08407843
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ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT			UNIT	QUANTITY DUE
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION	NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
					CUTTING TOLERANCE	SHIPPING TOLERANCE					
01	80	KG	0	DAA-897105-2	6061 /T6	MILL	5	999	954	KG	0
		M	0	D2500-1-190	190"	CERTIFICATE OF COMP			405.38	M	0
		PC	0		+5/16 "	(+010-010,0088-0072)			84	PC	0
					-0 "						
				LOT/TKT DETAIL:		63179010 / 358056	1	214	205		18 PC
						63179010 / 358057	1	214	205		18 PC
						63179010 / 358058	1	214	205		18 PC
						63179010 / 358059	1	214	205		18 PC
						63179010 / 358060	1	143	134		12 PC
02	80	KG	0	DAA-897122-1	6061 /T6	MILL	2	563	543	KG	0
		M	0	D2600-3-120	120"	CERTIFICATE OF COMP			234.70	M	0
		PC	0		+3/16 "	(+015-015,0092-0068)			77	PC	0
					-0 "						
				LOT/TKT DETAIL:		63179020 / 358180	1	327	317		45 PC
						63179020 / 358181	1	236	226		32 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

7	1562	1497	KG
		640.08	M
		161	PC
TOTALS			

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cart Date	Cart No	Sales Order	Page
05/25/10	206813	63179	1
Cust PO	B/L No	Lot	Date
11854	08407843	63179020	5/25/10

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
2.000	DAA-897122-1	120" Mill 6061 T6	D2600-3-120

Gross Weight	563 KGS
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Net Qty	543 KG	77 PC	235 M	2 PKG
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Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-08	<i>Selob6</i>

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	299.3 / 43.4	275.0 / 39.9	12.8	.0	94

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
.63	.28	.25	.10	.86	.06	.22	.02

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

D. VanBakel, QA Manager Signature Aluminum Canada Inc